

Date: Thursday, 8/16/2007 9:13:34 AM  
User: Jean-Luc Menard

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HOUSING WELDMENT		
Job Number	: 33982			Part Number	: D2207041		
Estimate Number	: 11874			Drawing Number	: D2207 UNDER REVIEW		
P.O. Number	:			Project Number	: N/A		
This Issue	: 8/16/2007	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: 11	Type	: LARGE FAB ASSY	Due Date	: 8/23/2007		
Previous Run	: 32219			Qty:	4	Um:	Each
Written By	<i>JL Menard 15</i>			Comment	: Est. C 01.10.18 Added Step 10 and 11. SM		

OK PER  
PREV ISSUE OF  
REV. C  
8/16/07

## Additional Product

Job Number:			
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Seq. #:	Machine Or Operation:	Description:		
1.0	D2208	End Cap		
				
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)				
End Cap				
Pick: <i>* 335095 = 8</i>				
Qty Part Number Description Batch <i>B13261</i>				
2 D2208 End cap				
2.0	D22071	Housing		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Housing				
Pick: <i>* 334326 = 4</i>				
Qty Part Number Description Batch <i>B33240</i>				
1 D2207-1 Housing				
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1		
				
Comment: LARGE FABRICATION RESOURCE 1				
Weld as per Dwg D2207				
Grind welds flush as per Dwg D2207				
i - Chamfer parts before Welding				
4.0	QC9	VISUAL WELDING INSPECTION		
				
Comment: VISUAL WELDING INSPECTION				
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
				
Comment: SMALL FABRICATION RESOURCE 1				
Drill holes using DT8557 as per Dwg D2207				
<i>FF 08-03-18 FF 07-08-21</i>				

334326

5 335095

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/03/18	#	welding sign is wrong of dwg at 08/03/18						

Part No: D2207-041 PAR #: N/A Fault Category: Prod / Fab. Large NCR:  No DQA:  Date: 08/03/18  
QA: N/C Closed:  Date: 08/03/19

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/18	#	All four (4) D2207-041's were found with the end caps (D2208) <u>welded</u> on the outside of the housing's, causing the weld to crack. R.C. old parts still in stock	J 08/03/18	Scrap all four and Replace.	D 08/03/18	C 08/03/18	J 08/03/18	E 08/03/18
	3.0							
08/03/18	3.0	weld all end caps on inside as per dwg. 4 pos. grid flush R.C. welding symbol is wrong on dwg	J 08/03/18	rework all parts Change symbol on dwg	L 08/03/18	G 08/03/18	J 08/03/18	J 08/03/18

NOTE: Date & initial all entries

wrong on dwg



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 33982

Part Number: D2207041

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>S 08/03/18 (4)</i>
	Comment: INSPECT WORK TO CURRENT STEP	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<i>FL 08/03/18 (4)</i>
	Comment: HAND FINISHING RESOURCE #1	
	Chemical Conversion Coat as per QSI 005 4.1	
8.0	POWDER COATING	POWDER COATING
		<i>M 107005</i> <i>(4)</i>
	Comment: POWDER COATING	
	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>M-1 08/03/18 (4X)</i>
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
10.0	ALS71032130	Insert
		<i>(4X)</i>
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)	
	Insert	
Qty	Part Number	Description Batch
4	ALS7-1032-130	Insert SEE QSI 017
		<i>M 105730</i> <i>m-1 08/03/18 (4X)</i>
11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		<i>(4X)</i>
	Comment: LARGE FABRICATION RESOURCE 1	
	Install AK57-1032-130 as per Dwg D2207	
12.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>S 08/03/18 (4)</i>
	Comment: INSPECT WORK TO CURRENT STEP	
13.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>(4X)</i>
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock	
	Location: 471	
		<i>8/3/18 56 (4X)</i>



Date: Thursday, 01/18/2007 9:13:34 AM  
User: Jean-François Mercier

## Process Sheet

Customer: QUDAR 001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 33982

Part Number: D2207041

Job Number:



Seq. #: Machine Or Operation:

Description:

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

12 08/03/19

Job Completion



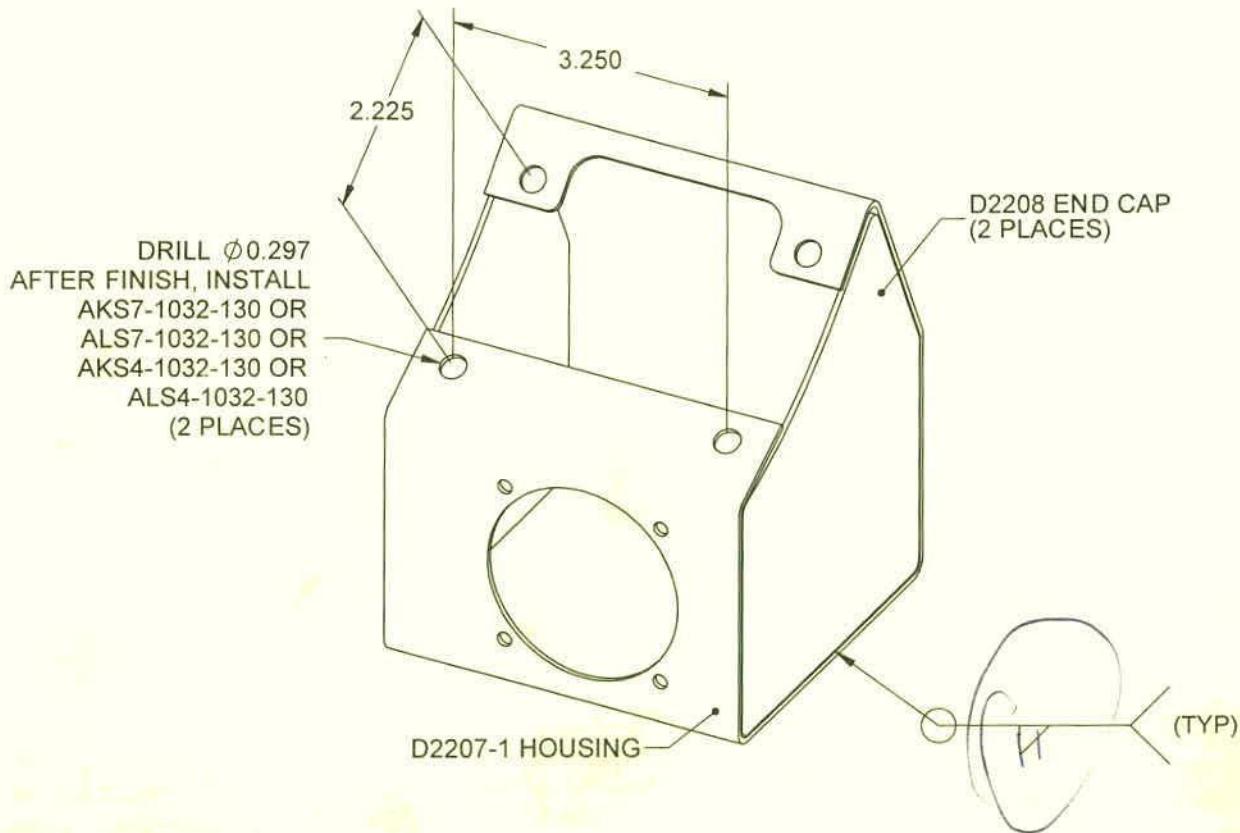
U 08/03/19



DESIGN <i>RF</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D2207	REV. C SHEET 1 OF 2	
DATE 07.06.28		TITLE HOUSING	SCALE 1:2	

REV	DATE	DESCRIPTION
A	94.09.01	NEW ISSUE
B	01.02.23	REDRAWN
C	07.06.28	REDESIGN



### D2207-041 FLAT PATTERN

**PRELIMINARY ISSUE**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

June 1863

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PRELIMINARY ISSUE

## D2207-1 HOUSING

## NOTES:

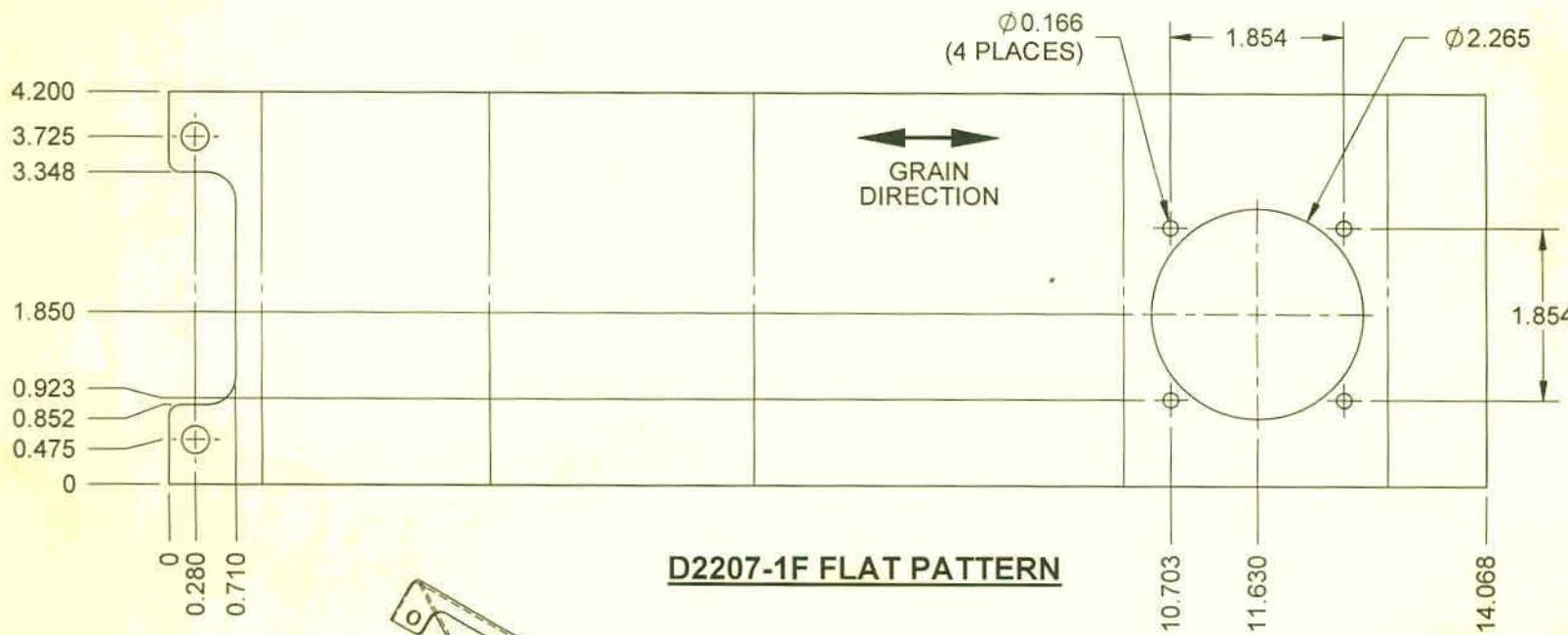
**NOTE: 1) MATERIAL:** 5052-32 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)

**2) FINISH:** NONE

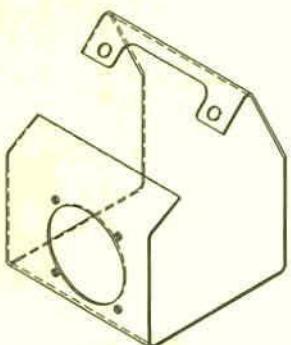
**3) TOLERANCES** ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

**4) ALL DIMENSIONS** ARE IN INCHES UNLESS OTHERWISE NOTED

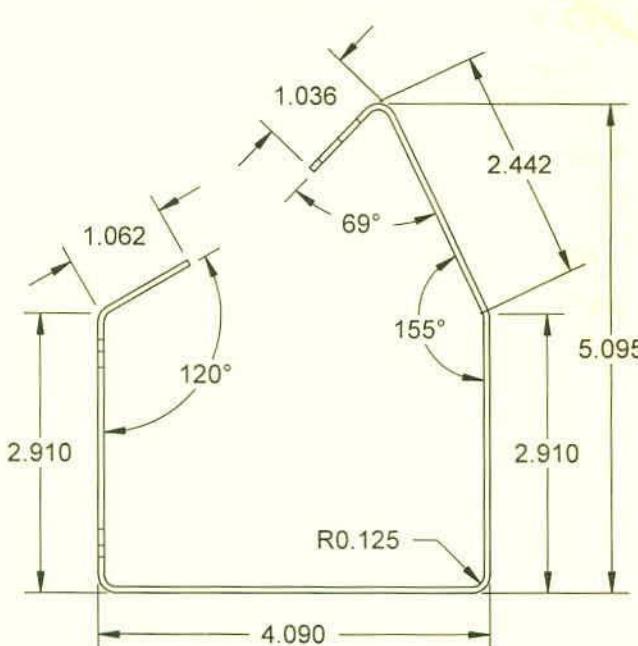
**5) BREAK ALL SHARP EDGES** 0.005 TO 0.010 MAX



D2207-1F FLAT PATTERN



**ISOMETRIC VIEW**  
(SCALE 1 : 4)



## D2207-1 BENDING DETAIL

DESIGN <i>P#</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>P#</i>	APPROVED	DRAWING NO. D2207	SHEET 2 OF 2
DATE 07.06.28	TITLE HOUSING	SCALE 1:2	

UNIVERSITY 220